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BRAZING METHOD OF MATERIAL MADE OF ALUMINUM

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[57] Abstract:

PURPOSE: To execute titled brazing without forming an oxidized film at all, by cladding a brazing material to an Al (light alloy) material, rolling it, and executing the working and assembling in a state that oil remains adhering, and heating it after evaporating the oil in a vacuum chamber. CONSTITUTION: One face or both faces of Al or an Al light alloy are cladded with a brazing material and are rolled. In case of this rolling, an oxidized film formed on the surface before that time is broken down, and also the broken oxidized film and scale are removed by rolling oil. Subsequently, a plate material being in a state that the rolling oil remains adhering onto the surface is worked, and for instance, a tube and a fin for constituting the parts of a heat exchanger are formed. Subsequently, formed parts are assembled, and the formed assembly is put into a vacuum chamber. It is degreased by evaporating the oil in a vacuum degreasing chamber for constituting the vacuum chamber, subsequently, vacuum brazing is executed by heating in a vacuum brazing chamber, and it is cooled in a take-out chamber, and is then taken out.

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